

Work Order ID 62582

Page 1

Monday, October 04, 2010 1:47:56 PM

Item ID: PB67-43001-03

Accept



Setup Start



Revision ID:

Item Name: Aft Blade Fold Assembly

Stop



Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-10-04

QC: _____ Date: _____ SPC (Y/N): _____

Tooling: _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Pick Kit	10/10/12(13) SF
B67-43001-03	Rev C		

100



Small Fab

Small Fab

Small Fab

Small Fab

Memo

0.00

10.10.19 - 1 - 8

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001
page 2.□ 242 THREADLOCK batch: M109687

110



QC5- Inspect part completeness to step on W/O

0.00

1 10/10/19

QC

Quality Control

Memo

0.00

120



Identify as per dwg & Stock Location: _____

0.00

PP 63058

10/10/20 SF

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start



Revision ID:

Item Name: Aft Blade Fold Assembly

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Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/2010 JJ

MF

10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62582



Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec
C 10.09.24 as per Rev C dwg EC verified by:DD

IPP Rev

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 		Purchased		No		100	Each	165.0000	8	8		10/10/10	sf

SPRING SLOTTED PIN

Location	Loc Qty	Loc Code
ST400	165	
112813	65	
115827	100	

30345T21



Purchased No

100 Each 38.0000

1

8

10/10/10 sf

LANYARD

Location	Loc Qty	Loc Code
ST401	38	
17828	38	

30345T24



Purchased No

100 Each 46.0000

3

10/10/10 sf

LANYARDS

Location	Loc Qty	Loc Code
ST401	46	
111351	2	
112853	44	

X 1

30345T22

112853

10/10/10

LANYARDS

Pro

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-03 PAR #: _____ Fault Category: _____ NCR: Yes DQA: Date: 10/10/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 62582		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/19		QTY.(2) 30345 T22 CANTILEVERS USED INSTEAD OF QTY(2) 30345 T24 PC. 30345 T22 + 30345 T24 STORED IN SAME BEN	↓ 10/10/19	ACCEPTABLE DEVIATION THIS BIN ONLY. STILL FUNCTIONAL.	10.10.19 JL	10.10.19 JL	62582 10.10.19	10/10/19

NOTE: Date & initial all entries

Picklist Print

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Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

3408A98



Purchased

No

100

Each

14.0000

1



10/10/10SF

DETENT BALL SPRING PLUNG

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST401	14	
<u>111078</u>	4	
<u>115703</u>	10	

AN4-10A



Purchased

No

100

Each

118.0000

2



10/10/10SF

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	118	
<u>113422</u>	1	
<u>114523</u>	77	
<u>115835</u>	40	

AN4-13A



Purchased

No

100

Each

480.0000

1



10/10/10SF

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST358	480	
<u>115159</u>	480	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-15A



Purchased

No

100

Each

577.0000

4

4



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST338	112	
ST358	465	
<u>107737</u>	12	
108868	60	
109148	4	
111295	52	
112905	12	
114232	3	
114292	32	
114615	56	
114784	58	
115108	76	
115371	100	

AN5-26A



Purchased

No

100

Each

28.0000

1

1



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	28	
112492	28	

AN6-11A



Purchased

No

100

Each

84.0000

2

2



BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST342	84	
<u>105558</u>	4	
111177	30	
114437	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN6-16A



Purchased

No

100

Each

38.0000

2

2

W1010108

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST342	38	
	38	

AN8-13A



Purchased

No

111636

100

Each

18.0000

2

2

W1010108

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST345	18	
	18	

BSP43



RIVET

Purchased

No

110915

100

Each

62.0000

3

3

W1010108

CR3213-4-05



cherry rivet

Purchased

No

111127

100

Each

140.0000

1

1

W1010108

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST284	62	
	50	
	12	

110704108473108991

140

41

99

1

1

W1010108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3440-1

Manufactured No

100

Each

11.0000

1



Tube Guide (Supersedes B67-43001-25/-307)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST441	11	
40047	8	
41347	3	

D3440-3

Manufactured No

100

Each

3.0000

1



Clamp (Supersedes B67-43001-309)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST441	3	
41348	3	

D3444-1

Manufactured No

100

Each

7.0000

1



Velcro Loop Belt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST441	7	
41457	7	

D3447-9

Manufactured No

100

Each

8.0000

2



Swing Arm

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST442	8	
46263	2	
57745	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

D3449-1



Pad

Manufactured

No

100

Each

6.0000

1

1

10/10/10SF

D3451-043



Handle and Lock-Down Assembly

Manufactured

No

Location
FG
62128Loc Qty
6
6Loc Code

100

Each

2.0000

1

1

10/10/10SF

D3451-045



Handle and Lock-Down Assembly

Manufactured

No

Location
ST442
52566Loc Qty
2
2Loc Code

100

Each

2.0000

1

1

10/10/10SF

D3922-1



Clip

Manufactured

No

Location
ST442
52567Loc Qty
2
2Loc Code

16.0000

1

1

1

10/10/10SF

MS17984-C408



PIN, QUICK RELEASE

Purchased

No

Location
ST096
48459Loc Qty
16
16Loc Code

13.0000

1

1

1

10/10/10SF

Location
ST314
111279
112940Loc Qty
13
3
10Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS17984-C418

Purchased

No

100

Each

30.0000

3

3



PIN, QUICK RELEASE

*10/10/13 SP*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST314	24	
111359	2	
<u>112940</u>	2	
<u>114523</u>	20	
ST463	6	
<u>114416</u>	6	

MS21042L4

Purchased

No

100

Each

4,434.000

9



Nut

*10/10/13 SP*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	4434	
113422	68	
114523	8	
114718	16	
114784	32	
<u>115108</u>	1310	
<u>115589</u>	1900	
115621	1100	

MS21042L5

Purchased

No

100

Each

899.0000

1



Nut

*10/10/13 SP*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	26	
114813	26	
ST300	873	
<u>115156</u>	373	
115594	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

100

Each

244.0000

4

4

Nut



10/10/1359

MS24694-S109

Purchased

No

100

Each

50.0000

2

10/10/138

Screw, Flat Head



(PTO)

MS27039-1-07

Purchased

No

100

Each

211.0000

1

10/10/138

Screw



MS27039-1-23

Purchased

No

100

Each

28.0000

1

10/10/138

SCREW



SCREW

LocationLoc QtyLoc Code

ST291

211

18106

ST292

28

18057

10/10/138

1

W/O: 62582		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-10-08		MS24694-S101 TOO LONG. PERMANENT CHANGE TO MS24694-S102 <i>OK for Park</i>				10-10-08 S102	

Part No: PB67-43001-03 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS51859-6



Purchased

No

100

Each

121.0000

8

8

10/10/138

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST296 111279 112940	121 21 100	

MS51859-7



Purchased

No

100

Each

25.0000

2

2

10/10/138

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST296 111193	25 25	

MS51859-8



Purchased

No

100

Each

63.0000

8

8

10/10/138

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST296 112940	63 63	

NAS1149F0316P



Purchased

No

100

Each

287.0000

1

1

10/10/138

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275 112940 113237 113644	287 87 100 100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

290.0000

16

16

10/10/13SF

Washer



NAS1149F0532P
WASHER

Purchased

No

Location

ST275

Loc Qty

290

Loc Code

112940
114405
114576
114718
115698

92
1
10
8
179

NAS1149F0632P

Purchased

No

100

Each

481.0000

8

8

10/10/13SF

WASHER



NAS1149F0832P

Purchased

No

Location

ST275

Loc Qty

481

Loc Code

18057

481

2

2

10/10/13SF

WASHER



NAS43DD3-61

Purchased

No

—

100

Each

0.0000

1

1

10/10/13SF

PTO.

Spacer

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

1

10/10/13SF

362309

Aft Blade Fold Assembly Weldment

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

1

10/10/13SF

362364

10/10/15

Aft Adjustable Blade Support Assembly



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Shop Packet Print

Page 10

W/O: 62582		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.18		ADD FOLLOWING ITEM: NAS1149 FO 532P, GTT=2. PERMANENT CHG.	M	10.10.20		10.10.18 Sion	10.10.20

Part No: PB67-43001-03 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 10/10/20

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 62582		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.15		NAS 43 003-68 CUT TO LENGTH OF NAS 43 003-61: 0.953". RC: NO STOCK FOR -61.	10.10.15	ACCEPTABLE DEVIATION.	10.10.19 M	10.10.19	10.10.15	10.10.19

NOTE: Date & initial all entries

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Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-135



Manufactured

No

100

Each

6.0000

1

10/10/13SL

Male Eye

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST446	6	
-------	---	--

45000	6	
-------	---	--

100	Each	0.0000
-----	------	--------

1

1

PB67-43001-137



Manufactured

No

45000

100

Each

0.0000

1

1

10.10.19

Locking Sleeve

PB67-43001-155



Manufactured

No

344999

100

Each

16.0000

1

1

10/10/13SL

Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST446A	16	
--------	----	--

43092	16	
-------	----	--

100	Each	0.0000
-----	------	--------

1

1

1

PB67-43001-17



Manufactured

No

43092

100

Each

0.0000

1

1

362369

10.10.15

Aft Adjustable Blade Support Assembly

PB67-43001-21



Manufactured

No

100

Each

0.0000

1

1

362370

10.10.15

PB67-43001-21



Manufactured

No

100

Each

0.0000

1

1

362371

10.10.15

PB67-43001-23



Manufactured

No

100

Each

5.0000

2

2

10/10/13SL

PB67-43001-261



Manufactured

No

100

Each

5.0000

2

2

10/10/13SL

Lever Arm

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST432	5	
-------	---	--

52493	5	
-------	---	--

2

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-265

Manufactured

No

100

Each

20.0000

5

5

10/10/1381

Deltin Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST439	20	
40056	15	
52494	5	

PB67-43001-299

Manufactured

No

100

Each

20.0000

2

2

10/10/1381

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST439A	20	
44969	20	

PB67-43001-305

Manufactured

No

100

Each

3.0000

1

1

10/10/1381

Bearing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST439A	3	
47044	3	

PB67-43001-37

Manufactured

No

100

Each

1.0000

1

1

10/10/15

Tube Arm Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST446	1	
53250	1	

PB67-43001-57

Manufactured

No

100

Each

0.0000

1

1

10/10/1381

Stabilizer Arm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-59



Manufactured No

100

Each

1.0000

1

1



10/10/13SL

PB67-43001-59

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST437A	1	
--------	---	--

53308

→

1

1

PB67-43001-63



Manufactured No

100

Each

2.0000

1



10/10/13SL

Handle Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST444	2	
-------	---	--

53243

→

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

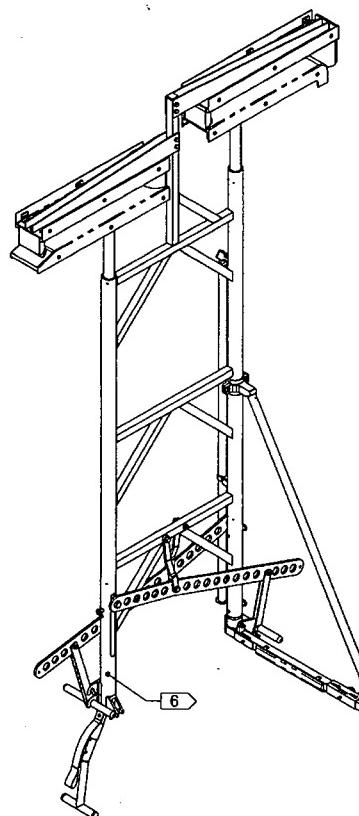
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -03	P/N	DESCRIPTION
X	B67-43001-03	AFT BLADE FOLD ASSY	
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELRIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
C	17	D3440-1	TUBE GUIDE
	18	D3440-3	CLAMP
	19	D3444-1	VELCRO LOOP BELT
	20	D3447-9	SWING ARM
	21	D3449-1	PAD
	22	D3451-043	HANDLE & LOCK-DOWN ASSY
	23	D3451-045	HANDLE & LOCK-DOWN ASSY
	24	D3922-1	CLIP
B	25	30345T21	LANYARD
	26	30345T24	LANYARD
	27	3408A98	DETENT BALL PLUNGER
	29	AN4-10A	BOLT
	30	AN4-13A	BOLT
	31	AN4-15A	BOLT
	32	AN5-26A	BOLT
	33	AN6-11A	BOLT
	34	AN6-16A	BOLT
	35	AN8-13A	BOLT
	36	BSP43	RIVET
	37	CR3213-4-05	RIVET
	38	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
	39	MS17984-C408	QUICK RELEASE PIN
	40	MS17984-C418	QUICK RELEASE PIN
A	41	MS21042L4	NUT
	42	MS21042L5	NUT
	43	MS21042L6	NUT
	44	MS24694-S109,	SCREW
	45	MS27039-1-07	SCREW
	46	MS27039-1-23	SCREW
	47	MS51859-6	NYLON WASHER
	48	MS51859-7	NYLON WASHER
	49	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
X	B67-43001-03	AFT BLADE FOLD ASSY	
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0316P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER

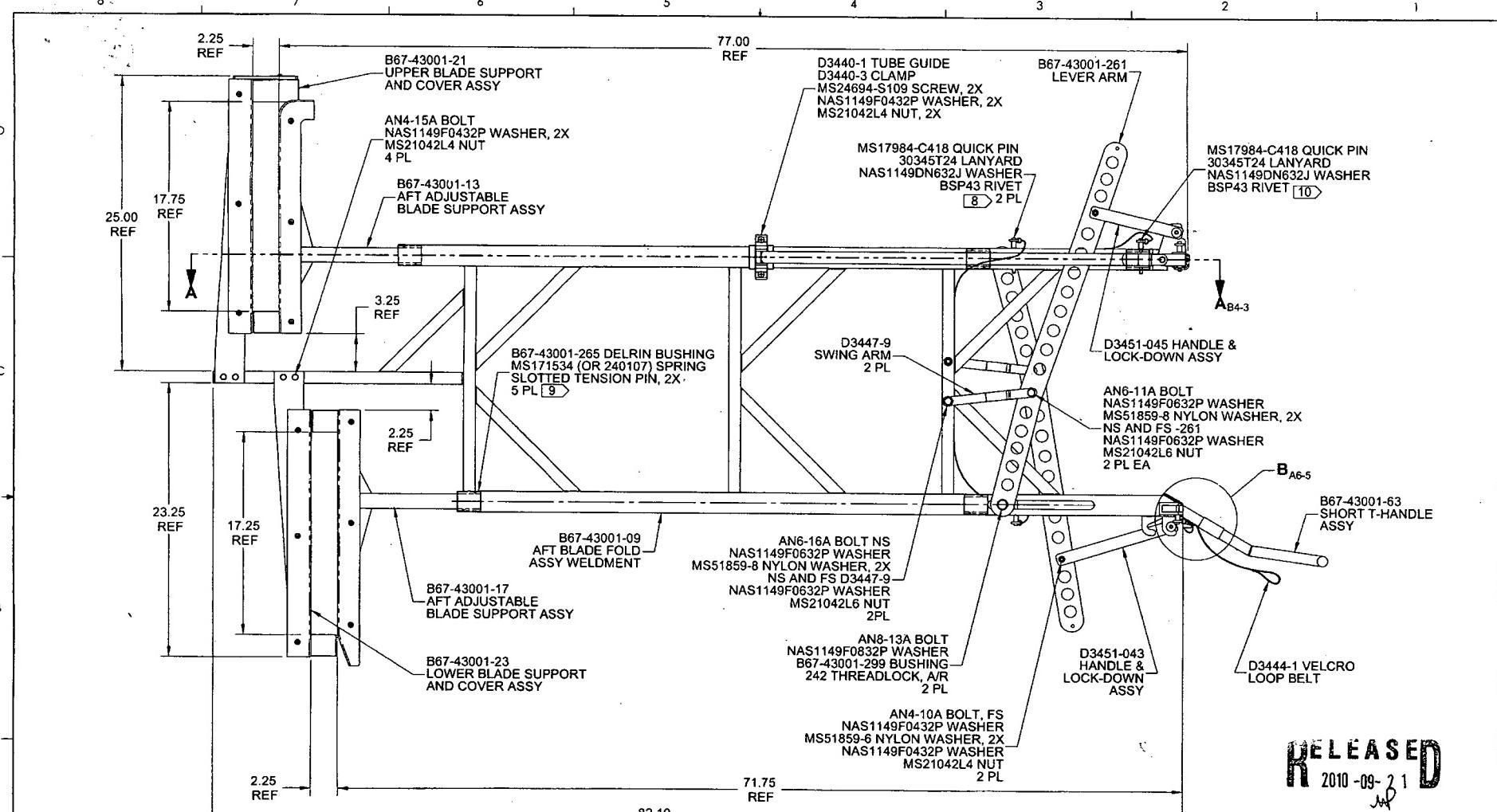
- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
 - 7) WEIGHT: 50.57 lbs
 - 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL Ø.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
 - 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 10 PL (2 PL PER BUSHING)
 - 10) DRILL Ø.250 DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
 - 11) DRILL A Ø.128 DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
 - 12) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A Ø.128 DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
 - 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.



B67-43001-03 AFT BLADE FOLD ASSY

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND CORRECTS PREVIOUS REVISIONS. REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011			VS	10.06.14
REV.	DESCRIPTION	BY	DATE		
DESIGN	RW			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS			DRAWING NO.	REV. C
CHECKED				B67-43001-03	SHEET 1 OF 5
MFG. APPR.				APPROVED	TITLE
DE APPR.	V/A			AFT BLADE FOLD ASSY	SCALE NTS
DATE	10.06.14			COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS FOR INTERNAL USE ONLY AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

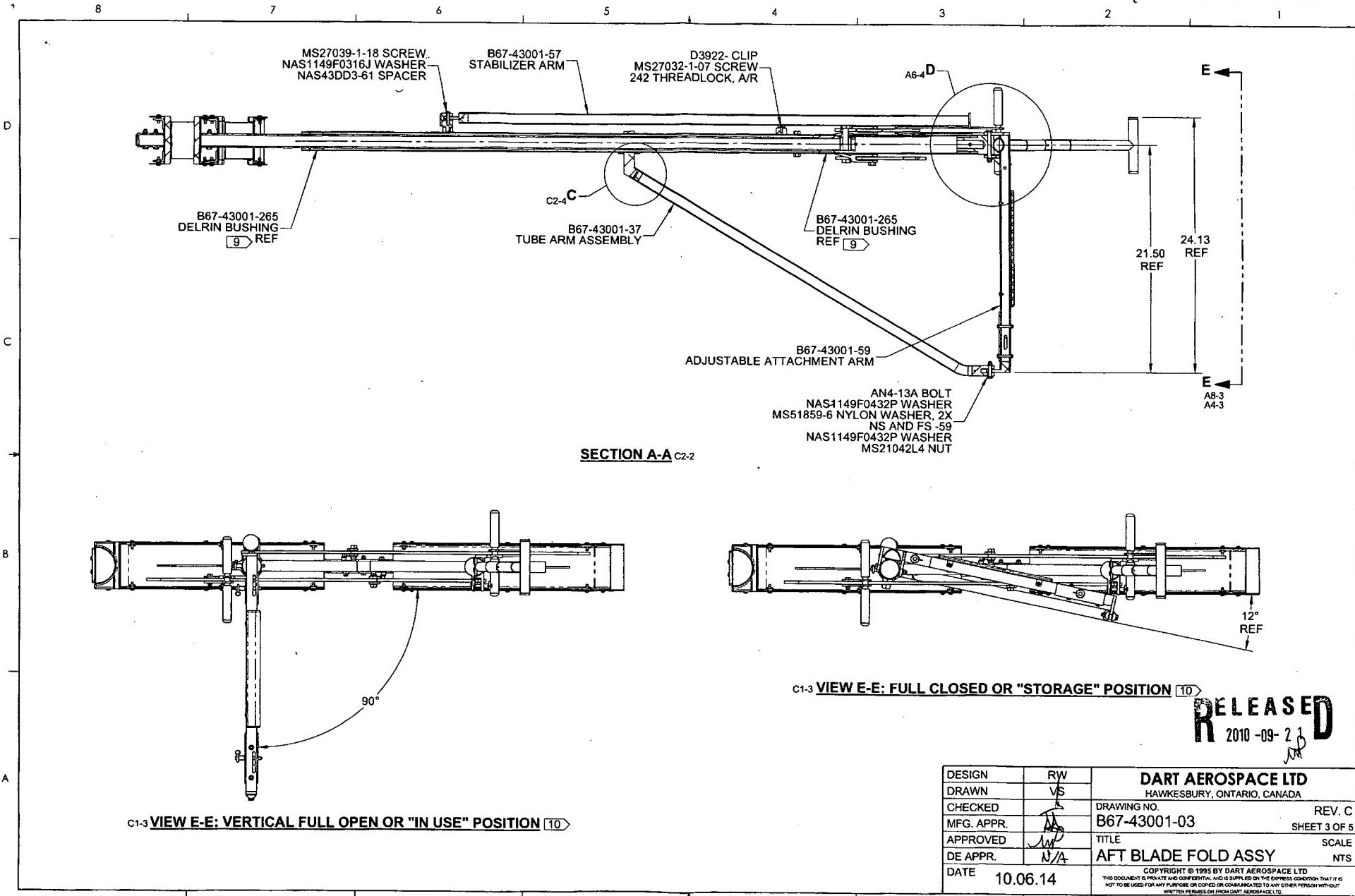
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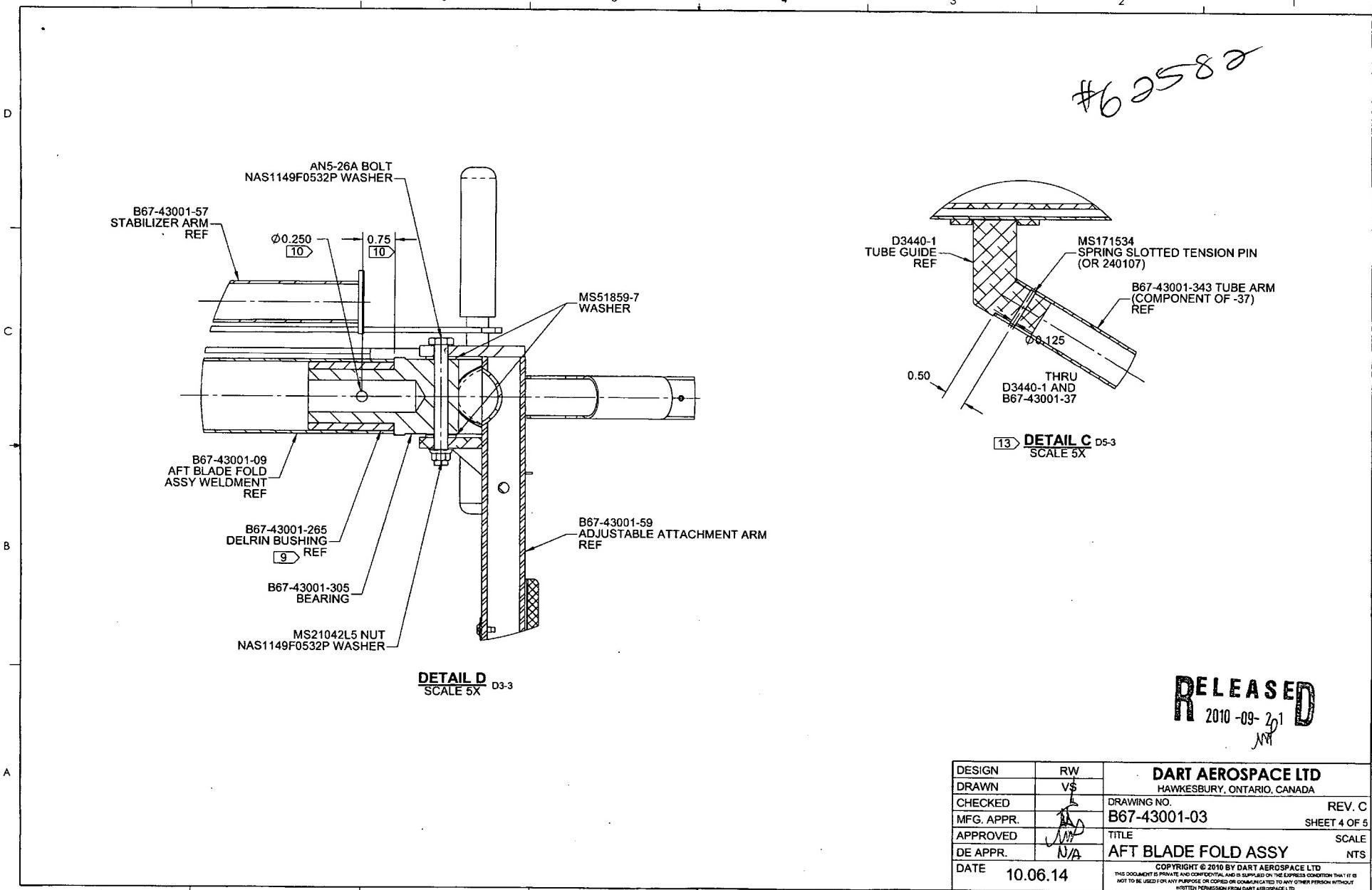
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DESIGN	RW	DART AEROSPACE LTD
DRAWN	V6	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.	AJ	B67-43001-03
APPROVED	MM	REV. C
DE APPR.	N/A	SHEET 2 OF 5
DATE	10.06.14	TITLE
		SCALE
		NTS
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JAD	B67-43001-03	SHEET 4 OF 5
APPROVED	JAD	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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